

Work Order ID 81485

March-14-12 4:21:13 PM

Setup
March 30
ASAP
81485

Page 1

Item ID: D4297-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bearpaw
Start Date: 14/03/2012 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 30/03/2012 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4297	B								
120		0.00							
120	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130		0.00							
130	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA028 and Dwg DWG REV: <u>S</u> FOLIO REV: <u>AA</u> 3-Deburr								

B12-3-20

36
inches

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81485

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 14/03/2012 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 30/03/2012 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140									
QC	Memo	0.00				12	Ø		SC 12/03/25
Quality Control									
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00				12	Ø		D.A 12/03/26
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									PP81489 C12/3/27 (12)

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 14/03/2012 Start Qty: 12.00

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Cust Item ID:

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/3/28 J

2120327

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Picklist Print

March-14-12 4:21:16 PM

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Work Order ID: 81485

81485

Parent Item: D4297-1

D4297-1

Parent Item Name: Bearpaw

Start Date: 14/03/2012

Required Date: 30/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-01-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	642.5059		44.4			
MUHMWB10									**				
UHMW 1" Black													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	385.3815789	
120035	67.7815789	
120401	197.6	
120972	120	
MAT019	257.1243158	
117321	74.6	
117738	93.28	
117819	83.3	
118814	1.5	
119145	4.44431579	

120035

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DART AEROSPACE LTD		Work Order:	81485
Description: Bearpaw		Part Number:	D4297-1
Inspection Dwg: D4297 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓		Dial Caliper	Bl 05
B	5.500	+/-0.030	5.507	✓			
C	0.75	+/-0.030	.767	✓			
D	0.25 x 45°	+/-0.030	.245	✓			
E	R0.250	+/-0.030	.250	✓			
G	0.63	+/-0.030	.640	✓			
H	0.38	+/-0.010	.402	✓			
I	0.950	±0.030/0.010	.965	✓			
J	19.000	+/-0.030	19.00	✓		Tape	Bl 09
K	3.14	+/-0.030	3.14	✓			Bl 05
M	Ø0.260	+0.005/-0.000	.260	✓			"
N	Ø0.93	+/-0.030	.932	✓			"
O	0.30	+0.030/-0.000	.310	✓			"
P	23.750	+/-0.030	23.75	✓			Bl 09
Q	7.375	+/-0.030	7.385	✓			Bl 06
R	4.250	+/-0.010	4.255	✓			
S	2.000	+/-0.030	2.020	✓			
T	9.000	+/-0.010	9.002	✓			
U	9.000	+/-0.010	9.000	✓			

Measured by: FL	Audited by: G.A	Preliminary Approval:
Date: 12/07/25	Date: 12/03/26	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue P/O D350-578-013	KJ	
B	12.02.01	Dwg Rev updated	KJ	

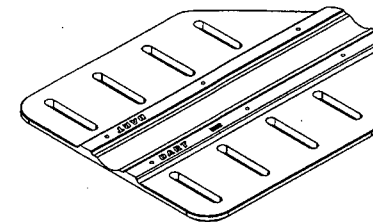
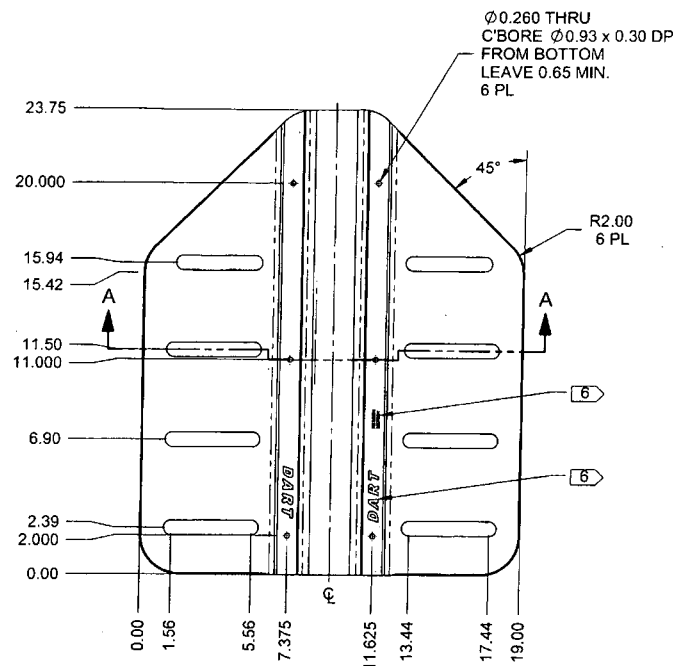
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81485 MLC

12/03/14

RELEASED
2011-11-04
ECN# 11-632

D4297-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4297-1" AND B/N "BXXXXX" USING 0.13 HIGH LETTERS TO MAX DEPTH OF 0.010
ENGRAVE WITH DART LOGO USING 1.00 HIGH LETTERS TO MAX. DEPTH OF 0.015
- 7) WEIGHT: 8.27 lbs

B	BOTTOM CHAMFER CHANGED FROM 0.125" TO 0.250", ZN B8-2; TOP CHAMFER CHANGED FROM .125" TO 0.062", ZN C8-2 (REF PAR 11-80)	XDF	11.10.25
A	NEW ISSUE	RF	10.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.	13	D4297	SHEET 1 OF 2
APPROVED	13	TITLE	SCALE
DE APPR.	13	BEARPAW	NTS
DATE	11.10.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMINGATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

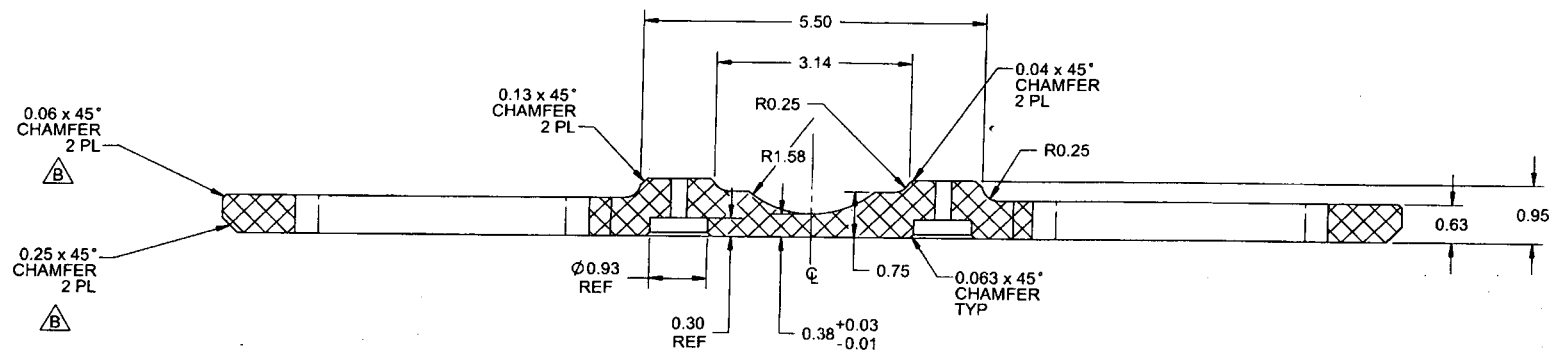
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SECTION A-A
SCALE 3X

RELEASED
2011-11-04

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4297	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BEARPAW	NTS
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